

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016359**Date Inspected:** 07-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006349

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

TOWER FACADE

SD1 – SFSA4 – 7A/B – 13; 14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 25A located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066443. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

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Weld joint # 25A located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1F/F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Beng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 34A located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 06615. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld build-up by shielded Metal Arc Welding (SMAW):

Weld build up being performed using backing bar located on Lift-4 skin-E Facade ND1 – SFSA4 – 336 as per the Weld Repair report # T-WR3477. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bao. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1. (See attached Photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 3B located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 17. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 3B located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 7. Welder is identified as 040656. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1. (See attached Photo)

Weld joint # 23 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 2B/F. Welder is identified as 066002. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint #30A located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 066258. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

ORTHOTROPIC BOX GIRDER (OBG) LIFT-13 AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 74 located on Bike Path panel Assembly BK004A6– 022. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

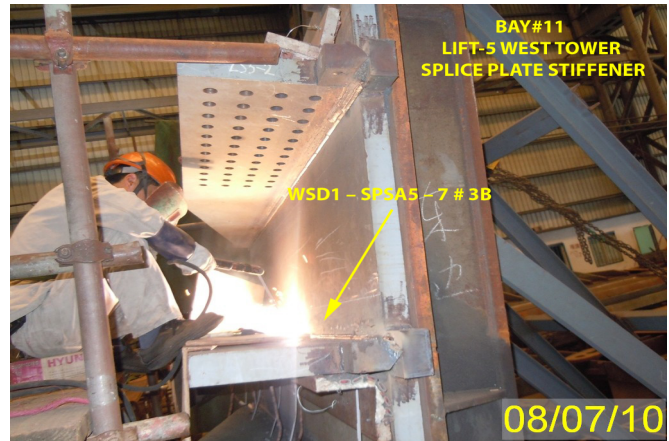
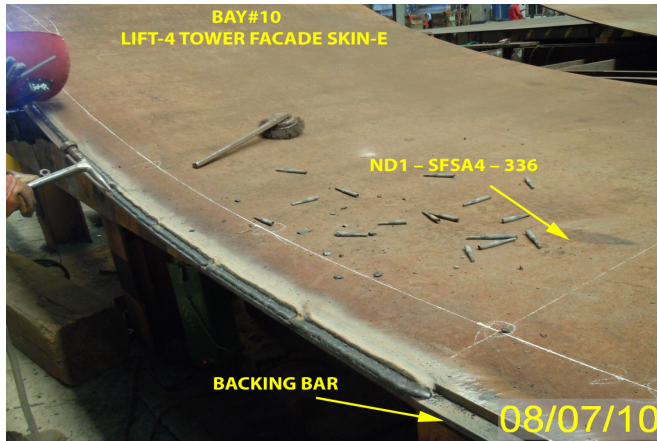
Weld joint # 75 located on Bike Path panel Assembly BK004A6– 021. Welder is identified as 042218. ZPMC

WELDING INSPECTION REPORT

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Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer